

Date: Wednesday, 11/07/2007 8:41:23 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 33332
 Estimate Number : 10749
 P.O. Number :
 This Issue : 11/07/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D33154
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3315 REV. B
 Previous Run : 33332 Project Number : N/A
 Material : B
 Due Date : 31/07/2007 Qty: 6 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature]
 Comment : Est: A 05.05.12 New issue KJ/JLM
 Est Rev:B As per Rev B 06-03-24 JLM
 Est Rev:C Now on Waterjet 07-07-11 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S16GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 2.4108 sf(s)/Unit Total: 14.4648 sf(s)
 1010/1025/A21/6aA SHEET .060" THK
 BATCH: M105261

SAD 07/08/16

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3315
 Dwg Rev: B
 Prog Rev: B

2-Deburr if necessary

07/08/22 DM SAN 07/08/16

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN 07/08/16

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

count
 En 07/09/18 (8)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: B

SB 07/09/19

Date: Wednesday, 11/07/2007 8:41:23 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33332

Part Number: D33154

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

En 21 01/17 (8) cauto

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3315-4T3 as per QSI 004 and Dwg D3315 Rev: B

Qty Part Number Description Batch

A/R N/A 7560 Hardcoat Rod

M 105686

FC 07/09/21 (8)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07-10-01 (3)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

07-10-02 (8)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07-10-03 (8)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-4, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: _____

07-10-03 (8)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.03

Job Completion



U 07-10-03

Date: Monday, 7/9/2007 11:42:15 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 33332		
Estimate Number	: 10749		
P.O. Number	:	Part Number	: D33154
This Issue	: 7/9/2007 S.O. No. :	Drawing Number	: D3315 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: B
Previous Run	: 26187	Material	:
Written By	:	Due Date	: 7/30/2007 Qty: 6 Um: Each
Checked & Approved By	: <u>7/07.07.09</u>		
Comment	: Est: A 05.05.12 New issue KJ/JLM Est Rev:B As per Rev B 06-03-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: _____
Email or Ship DXF file to vendor
Laser Cut flat pattern per Dwg D3315
Possible Supplier: Industrial Laser
Material release note is required

*M1005166A
2.2916SF*

W. Hege

2.0	D33154F	Wearplate Flat Pattern
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
WEARPLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per inspection template D3315-4T1

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33332

Part Number: D33154

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: _____

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3315-4T3 as per QSI 004 and Dwg D3315 Rev: _____

Qty	Part Number	Description	Batch
A/R	N/A	7560 Hardcoat Rod	_____

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-4, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:42:15 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 33332

Part Number: D33154

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

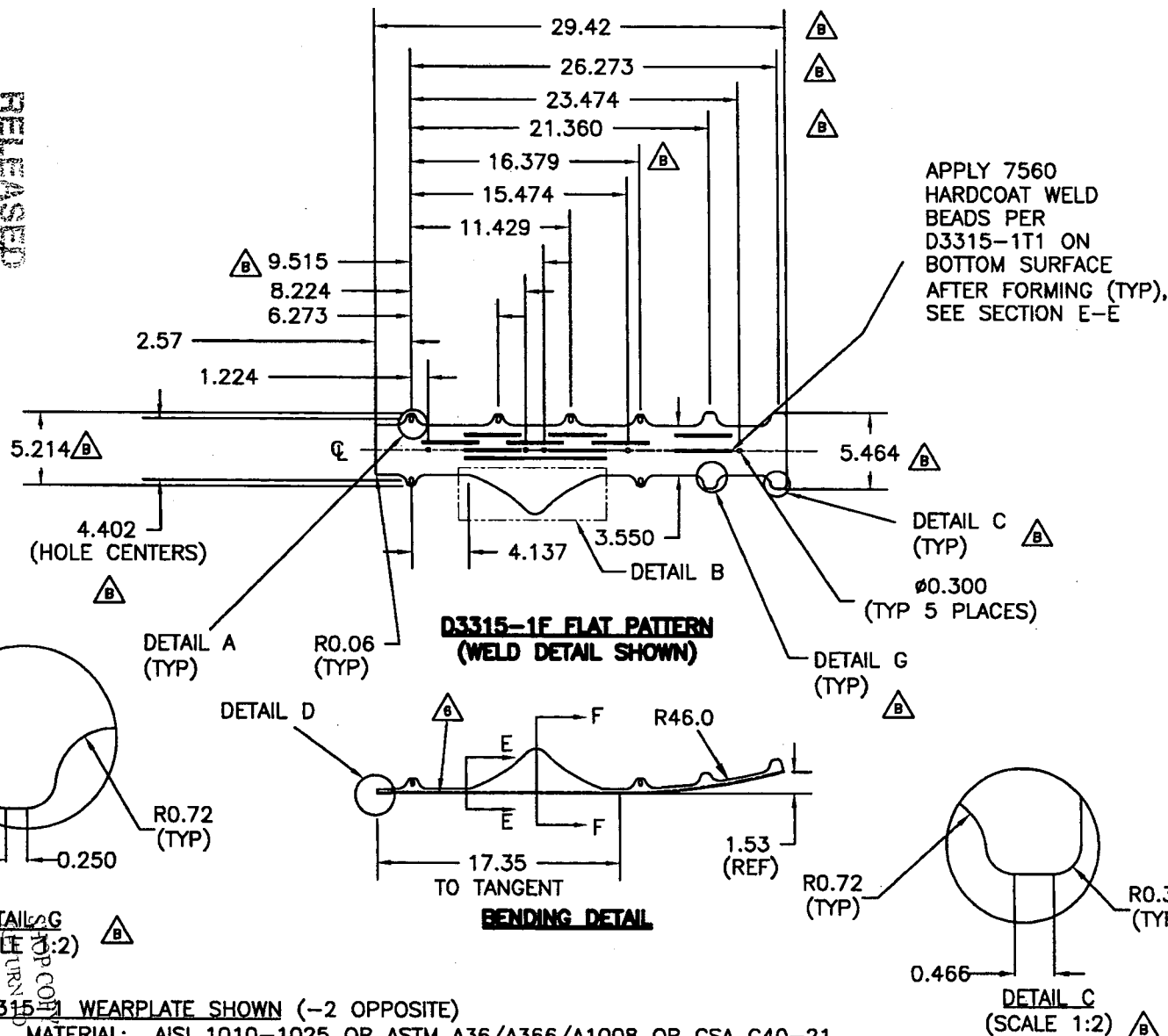
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D3315
DATE	06.01.31	TITLE	WEARPLATE	REV. B SHEET 1 OF 4
				SCALE 1:12
A	04.09.10	NEW ISSUE		
B	06.01.31	UPDATE DIMENSIONS		



RELEASED
06.03.20

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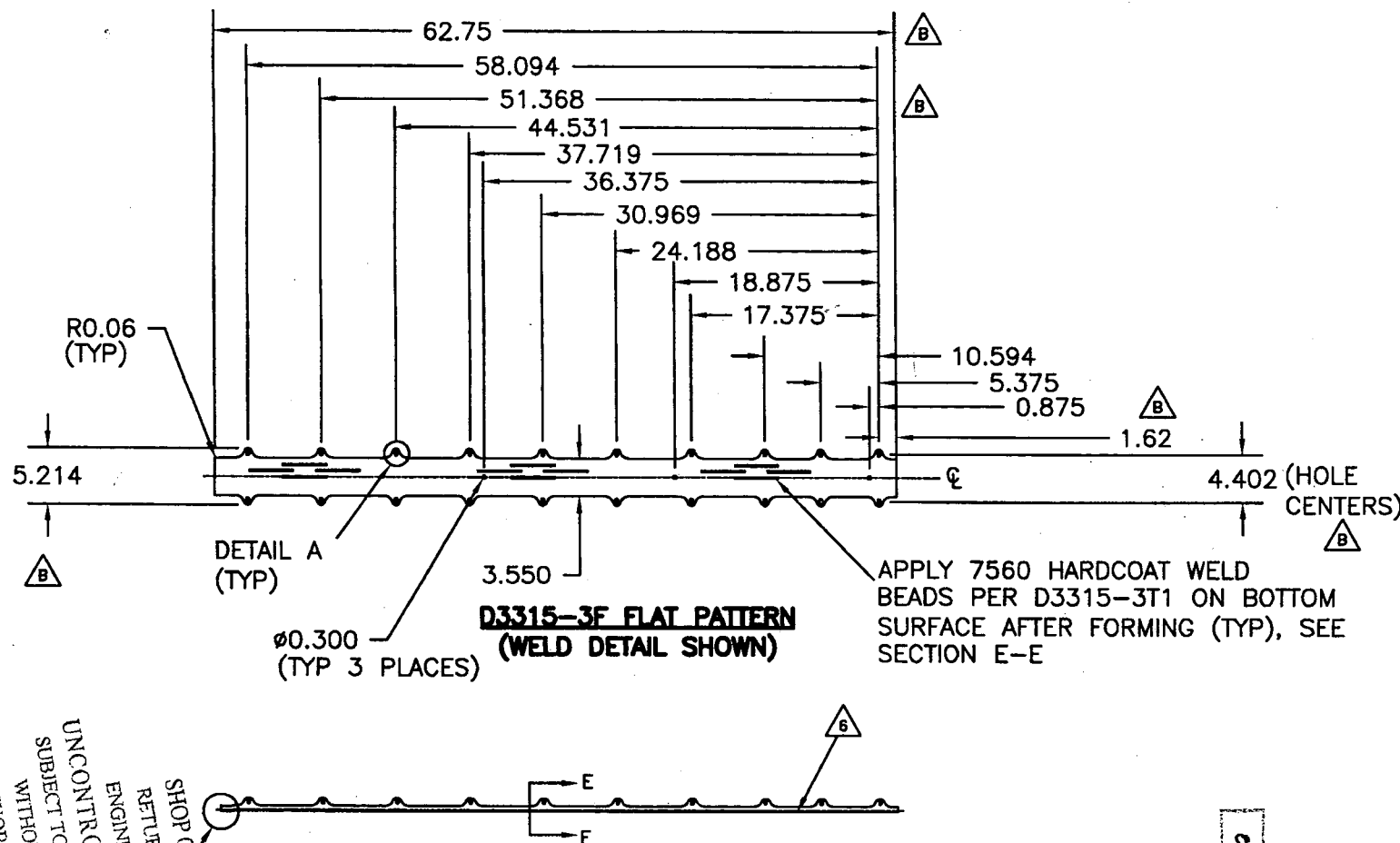
D3315-1F WEARPLATE SHOWN (-2 OPPOSITE)
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 WELD PER DART QSI 004
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
 *TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

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DART

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	TITLE	D3315	REV. B
		WEARPLATE		SHEET 2 OF 4
				SCALE 1:18



**D3315-3F FLAT PATTERN
(WELD DETAIL SHOWN)**

BENDING DETAIL

D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

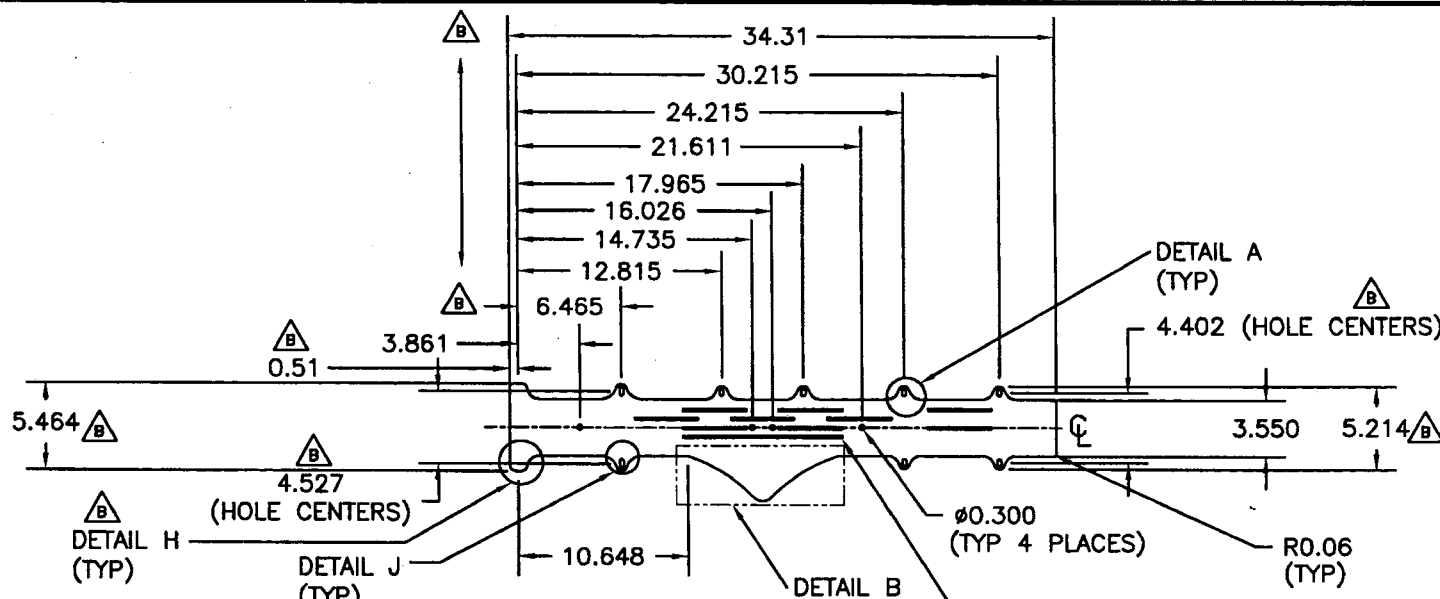
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

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06.03.20

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DETAIL D
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE

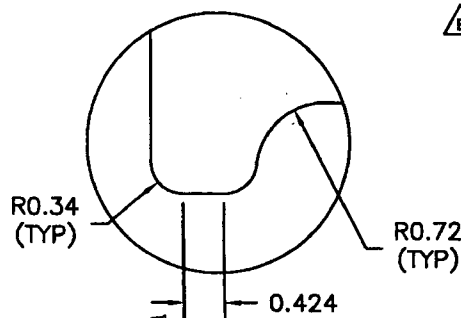
DART

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO. D3315
DATE	06.01.31	TITLE	WEARPLATE	REV. B
				SHEET 3 OF 4
				SCALE 1:12



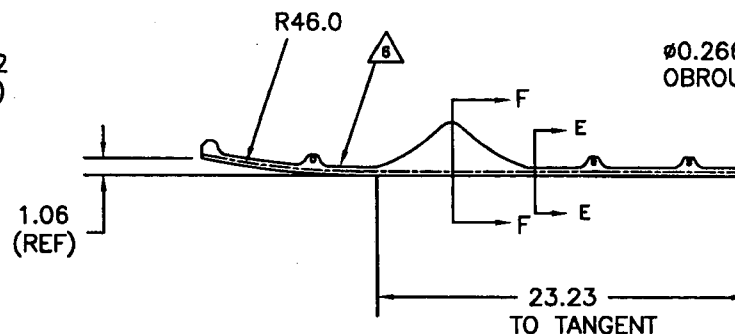
**D3315-5F FLAT PATTERN
(WELD DETAIL SHOWN)**

APPLY 7560 HARDCOAT WELD
BEADS PER D3315-5T1 ON BOTTOM SURFACE
AFTER FORMING (TYP), SEE SECTION E-E

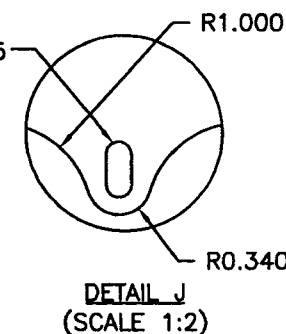


**DETAIL H
(SCALE 1:2)**

WORK ORDER
NO. 33332
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BENDING DETAIL



D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)

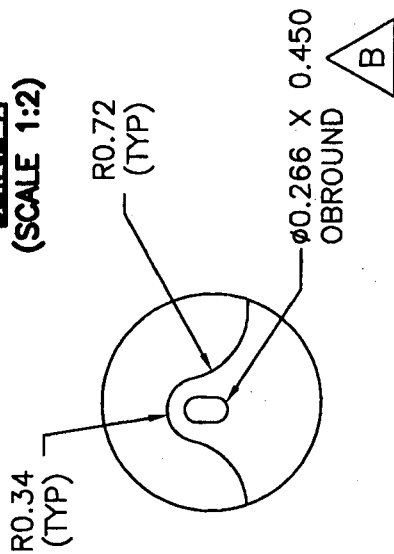
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSION ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED

*TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED
06 03 20

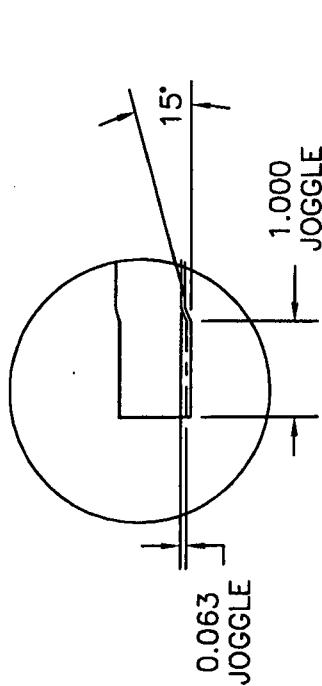
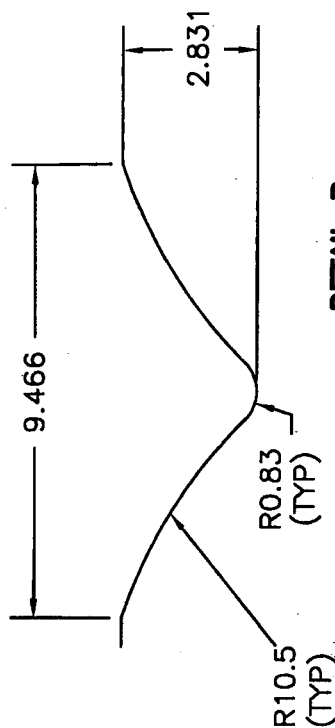
DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3315	REV. B SHEET 4 OF 4
DATE 06.01.31	TITLE WEARPLATE		SCALE NTS

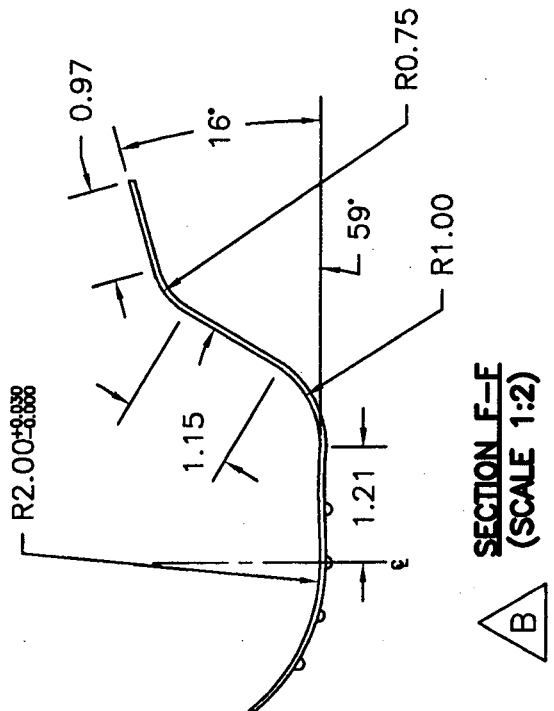
DETAIL A
(SCALE 1:2)

RELEASED

06.03.20

**DETAIL D**
(SCALE 1:2)**DETAIL B**
(SCALE 1:4)

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WITHOUT NOTICE
WORK ORDER
NO. 33332

**SECTION E-E**
(SCALE 1:2)**SECTION E-E**
(SCALE 1:2)

R2.00^{+0.030}_{-0.000}
(-1, -2, -5, -6 ONLY)
7560 HARDCOAT WELD
BEADS (TYP)
0.063 TO 0.125 HIGH
0.56 (TYP)

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